

ASAP 11

Work Order ID 56936

March 15, 2010 10:13:04 AM

Page 1

Item ID: D3781-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Supporting Plate

Start Date: 3/15/10 Start Qty: 6.00

Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: CL

Date: 10/3/15

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3781

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3781-1

Dwg Rev: 3

Prog Rev: 3

2- Deburr if necessary

10-3-15

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56936**

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Page 2

Item ID: D3781-1

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Stop

Item Name: Supporting Plate

Start Date: 3/15/10 Start Qty: 6.00

Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/15

(10)



QC

Memo

0.00

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3781  
2- deburr if necessary

8/10/16 (10)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/16

(10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56936**

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Page 3

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Item Name: Supporting Plate

Start Date: 3/15/10 Start Qty: 6.00

Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-8-16

10

10

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/03/16

10

10

170

0.00



Small Fab

Memo

0.00

Small Fab

1- assemble nut plate as per dwg

10/03/24 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56936**

March 15, 2010 10:13:04 AM

Page 4

Item ID: D3781-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Supporting Plate

Start Date: 3/15/10 Start Qty: 6.00

Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

S 10/03/24



QC

Memo

0.00

(10)

Quality Control

190

Identify as per dwg & Stock Location: U87

0.00



Packaging

Memo

0.00

10/03/24 (10)

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/03/24

Quality Control

C 10/03/24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March 15, 2010 10:13:04 AM

Page 1

Work Order ID: 56936

Parent Item: D3781-1

Parent Item Name: Supporting Plate

Start Date: 3/15/10

Required Date: 3/17/10

Comments: IPP RevA: revD as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

111.7997

0.6707

1.2



6061-T6 .080 Sheet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

111.79967

110630

35.0136

112141

0.86727

112763

0.19

113438

75.7288

MS20426AD3-3

Purchased

No

170

Each

5,643.000

24.0000



Rivet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST316

5643

19099

4776

7681

867

MS21075L3

Purchased

No

170

Each

20.0000

12.0000



Nutplate

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST303

20

112991

13

113734

7

1310-3-15

10

113438

8/5/10/03/24

40

8/5/10/03/24

M114227 (13x)

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Supporting Plate		<b>Part Number:</b>	D3781-1
<b>Inspection Dwg:</b> D3781	<b>Rev:</b> D	<b>Page 1 of 1</b>	

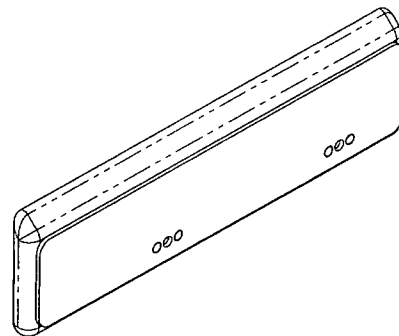
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

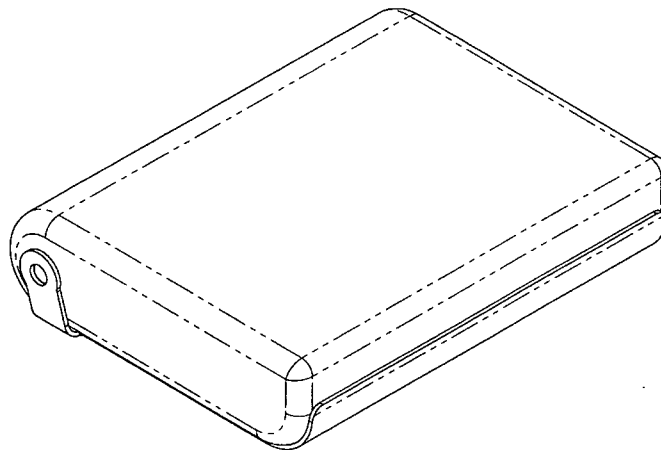
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.98	+0.004/-0.001	.100	✓			
Ø0.201	+0.005/-0.001	.201	✓			
1.500	+/-0.010	1.503	✓			
4.000	+/-0.010	4.000	✓			
0.250	+/-0.010	.250	✓			
0.500	+/-0.010	.501	✓			
0.375	+/-0.010	.376	✓			
1.80	+/-0.030	1.805	✓			
8.50	+/-0.030	8.499	✓			
0.080	+/-0.010	.078	✓			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-3-15	<b>Date:</b> 10/03/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AS



**D3781-041 LATERAL CUSHION ASSY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



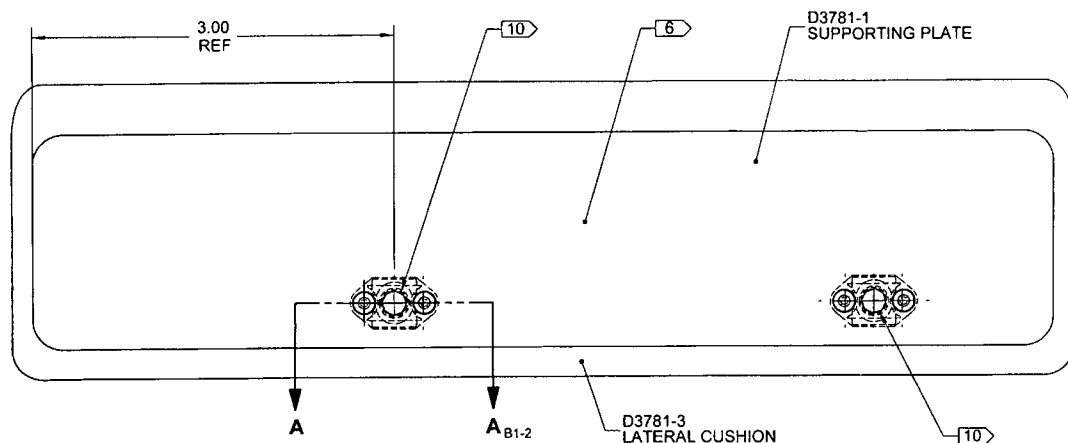
**D3781-043 ARMREST CUSHION**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

0210131 15  
WFO: 56936

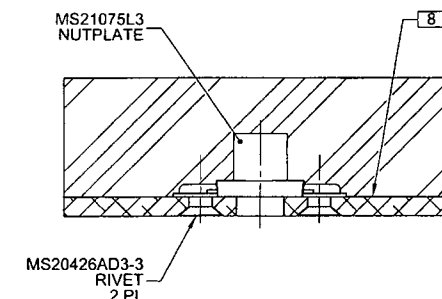
**RELEASED**  
09/01/2021

D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. <b>D3781</b>		REV. D	
TITLE <b>CUSHION ASSEMBLY</b>		SCALE	
		NTS	
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



**D3781-041 LATERAL LATERAL CUSHION ASSEMBLY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



**SECTION A-A** B6-2  
2 PL, SCALE 2X

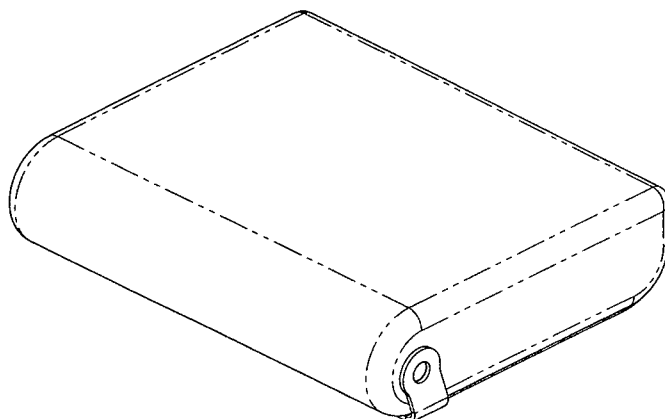
**D3781-041 NOTES:**

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.  
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS  
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS  
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

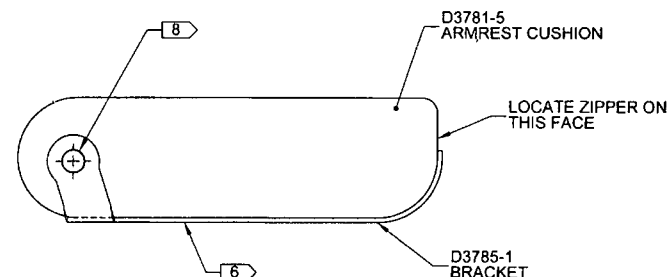
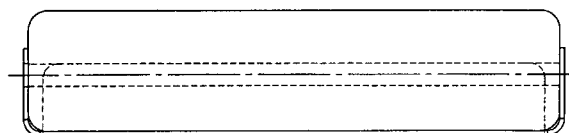
**RELEASED**  
29/07/14

DESIGN	1	<b>DART AEROSPACE LTD</b>	
DRAWN	ASS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. <b>D3781</b>	REV. D
MFG. APPR.	ND		SHEET 2 OF 6
APPROVED	AND	TITLE	SCALE
DE APPR.	AND	<b>CUSHION ASSEMBLY</b>	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS BURNED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
11	1	D3785-1	BRACKET
12	1	D3781-5	ARMREST CUSHION
21	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
22	A/R	1300	3M SCOTCH-GRIP ADHESIVE



**D3781-043 LATERAL ARMREST CUSHION BASE ASSY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



**D3781-043 NOTES:**

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.  
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS  
ZIPPER P/N: AI-Z021  
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

**RELEASED**  
09/07/14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AD</i>	D3781	SHEET 3 OF 6
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	CUSHION ASSEMBLY	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

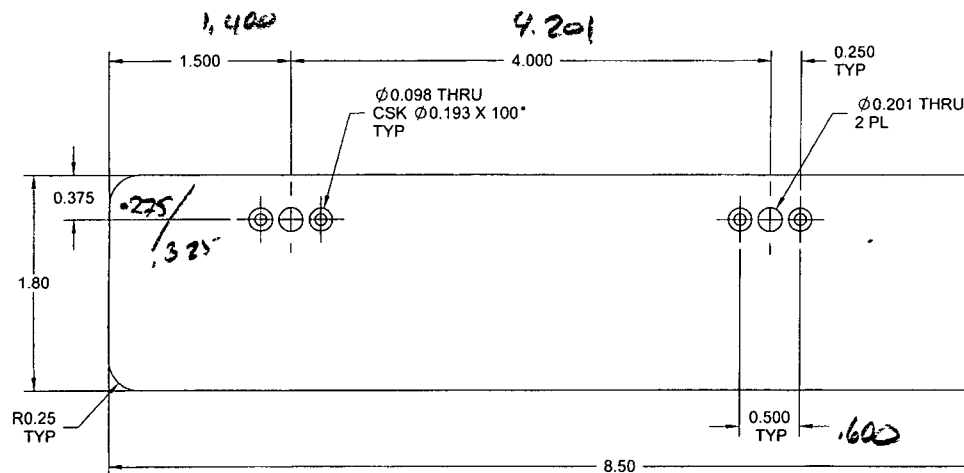
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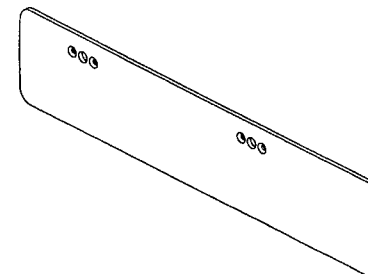
C

B

A



**D3781-1 SUPPORTING PLATE**

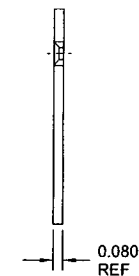


D

C

B

A



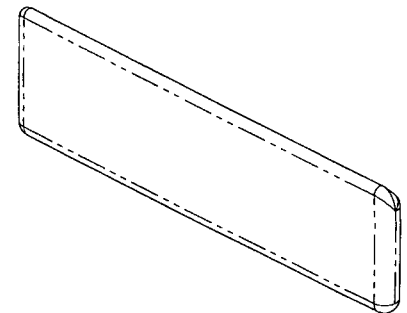
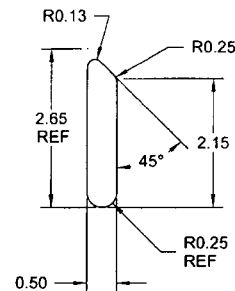
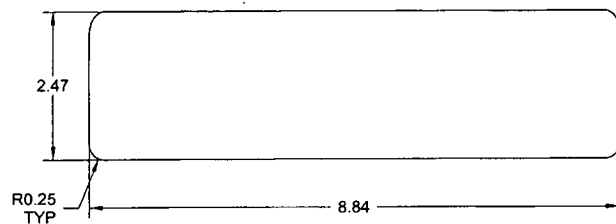
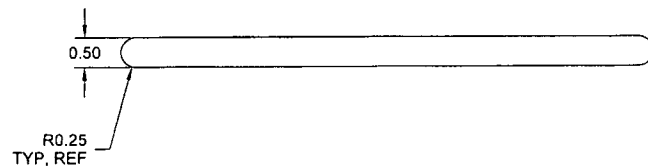
**RELEASED**  
09/07/14

**D3781-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	<b>D3781</b>	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CUSHION ASSEMBLY</b>	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



### D3781-3 LATERAL CUSHION

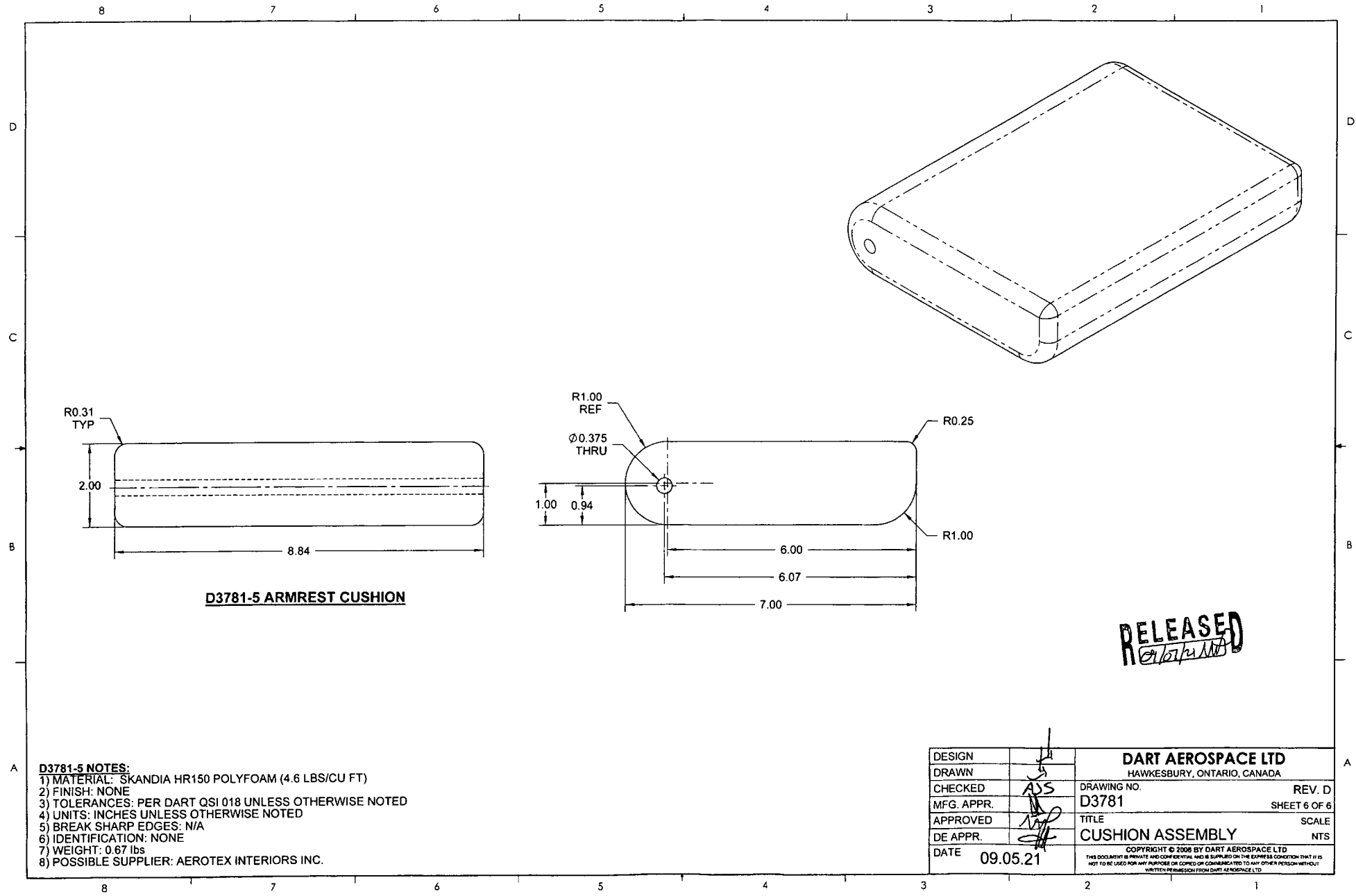
#### **D3781-3 NOTES:**

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

**RELEASED**  
3/16/21

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JS</i>	<b>D3781</b>	SHEET 5 OF 6
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	<b>CUSHION ASSEMBLY</b>	NTS
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D3781-5 ARMREST CUSHION

RELEASED  
01/01/2008

- D3781-5 NOTES:**
- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.67 lbs
  - 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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